

Date: Tuesday, 8/22/2006 2:15:23 PM
 User: Jean-Luc Menard

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : MOUNTING PLATE
Job Number : 28301	
Estimate Number : 12408	
P.O. Number :	Part Number : D34992
This Issue : 8/22/2006 S.O. No. :	Drawing Number : D3499 UNDER REVIEW
Prsht Rev. : NC	Project Number : N/A
First Issue : 1/1 Type : SMALL MED FAB	Drawing Revision : U/R
Previous Run : 27209	Material :
Written By : <i>[Signature]</i>	Due Date : 8/29/2006 Qty: 1 Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : Est Rev A New Issue 06-05-05 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S125	6061-T6 .125 Sheet
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Comment: Qty.: 1.1214 sf(s)/Unit Total : 1.1214 sf(s)
 6061-T6 .125 Sheet
 (M6061T6S0125)
 Batch: *M100947*

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D3499
 Dwg Rev: *UR*
 Prog Rev: *PREL* ?

2-Deburr if necessary

SAD 06:08:23

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 06:08:23

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
 Deburr if necessary.

Guig only

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MOUNTING PLATE

Job Number: 28301

Part Number: D34992

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Bend as per Dwg D3499

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

12.0

DC

DOCUMENT CONTROL



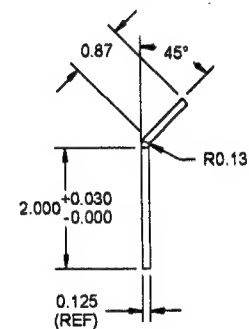
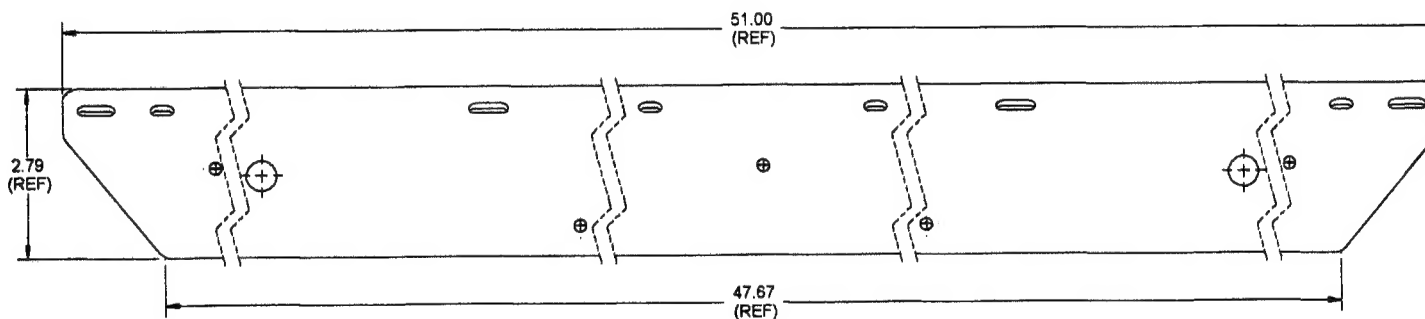
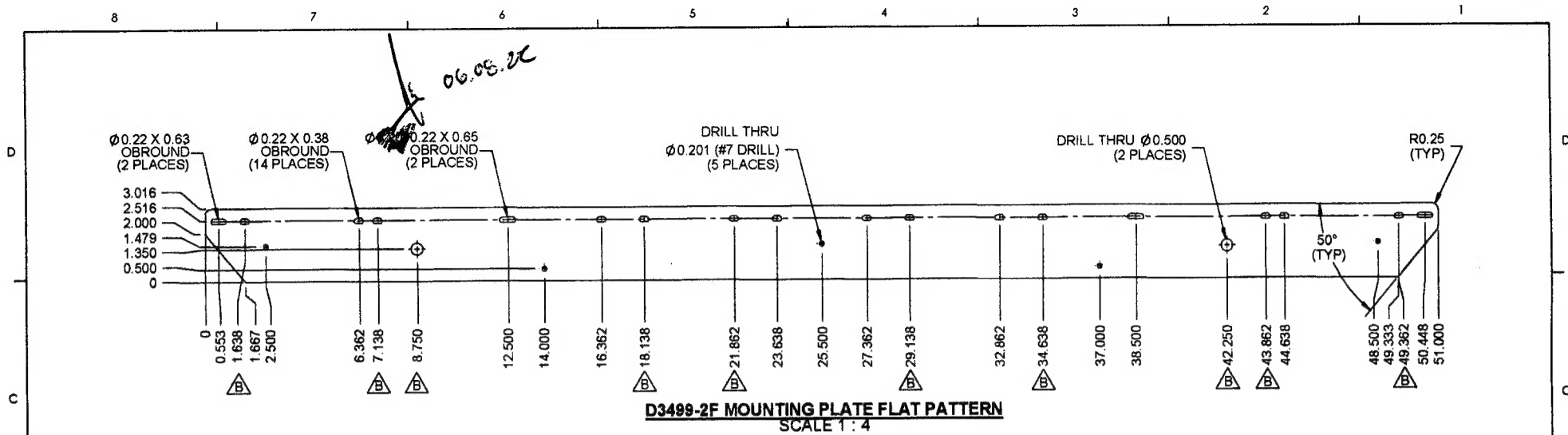
Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



Handwritten signature: J. D. 12.07



NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET (0.125 THICK)
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.125)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005.4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

PRELIMINARY ISSUE

DESIGN 	DRAWN BY 	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO. D3499	REV. B SHEET 2 OF 4
DATE 06.08.15	TITLE CABLE GUARD		SCALE 1:2
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DART AEROSPACE LTD		Work Order: 28301
Description:		Part Number: D34992
Inspection Dwg:	Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.553	±0.010	0.557	✓		Vern	
1.638	±0.010	1.643	✓		Vern	
1.667	±0.010	1.670	✓		measuring tape	
2.500	±0.010	2.495	✓		Vern	
6.362	±0.010	6.370	✓		Vern	
7.138	±0.010	7.148	✓		Vern	
8.750	±0.010	8.745	✓		Vern	
12.500	±0.010	12.509	✓		Vern	
14.000	±0.010	14.009	✓		Vern	
16.362	±0.010	16.370	✓		measuring tape	
18.138	±0.010	18.130	✓		measuring tape	
21.862	±0.010	21.870	✓		measuring tape / Vern	
23.638	±0.010	23.630	✓		measuring tape / Vern	
25.500	±0.010	25.500	✓		measuring tape / Vern	
27.362	±0.010	27.362	✓		measuring tape / Vern	
29.138	±0.010	29.130	✓		measuring tape / Vern	
32.862	±0.010	32.860	✓		measuring tape / Vern	
34.638	±0.010	34.630	✓		measuring tape / Vern	
37.000	±0.010	37.000	✓		measuring tape / Vern	
38.500	±0.010	38.500	✓		measuring tape	
42.250	±0.010	42.260	✓		measuring tape	
43.862	±0.010	43.870	✓		measuring tape / Vern	
44.638	±0.010	44.630	✓		measuring tape / Vern	

Measured by: JAD	Audited by:	Prototype Approval:
Date: 06/08/23	Date:	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

DART AEROSPACE LTD		Work Order:
Description:		Part Number:
Inspection Dwg:	Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
48.500	± 0.010	48.500	✓		measuring tape	
49.333	± 0.010	49.340	✓		measuring tape vern	
49.362	± 0.010	49.362	✓		measuring tape	
50.448	± 0.010	50.448 50.500	✓		measuring tape	
51.000	± 0.010	51.000	✓		measuring tape	
3.016	± 0.010	3.022	✓		Vern	
2.516	± 0.010	2.522	✓		Vern	
2.000	± 0.010	2.000	✓		Vern/M-T	
1.479	± 0.010	1.486	✓		Vern	
1.350	± 0.010	1.354	✓		Vern	
0.500	± 0.010	0.501	✓		Vern	
0.22 /	± 0.030	0.217	✓		Vern	
0.63	± 0.030	0.629	✓		Vern	
0.22	± 0.030	0.225	✓		Vern	
0.38	± 0.030	0.385	✓		Vern	
0.22	± 0.030	0.217	✓		Vern	
0.65	± 0.030	0.650	✓		Vern	
0.201	$+0.006/-0.001$	0.207	✓		Vern	
0.500	$+0.006/-0.001$	0.507	✓		Vern	
0.125	± 0.010	0.125	✓		Vern	

Measured by: SAP	Audited by:	Prototype Approval:
Date: 06.08.23	Date:	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	